

# Work Order ID 57965

April 21, 2010 9:17:22 AM



Page 1

Item ID: D4038-1

Accept



Setup

Start



Revision ID:

Item Name: Angle. Fwd. LH

Stop



Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
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Draw Nbr	Revision Nbr
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D4038	B
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100	
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Bandsaw	
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Jeaspa Bandsaw	
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Memo	0.00
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Cut Blank 7.125" long	
-----------------------	--

110	
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HAAS 1	
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HAAS CNC vertical machine #1	
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Memo	0.00
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Mill as per Dwg & Folio FA880	
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Dwg Rev: <u>B</u>	
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Folio Rev: <u>B</u>	
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Deburr	
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MW  
20/04/24

4. 0

MW  
10/04/24

4. 0

**Work Order ID 57965**

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Page 2

Item ID: D4038-1

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC2-Inspect parts off machine FAI/FAIB

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

*MW*  
*10/04/24*
*4* *0*

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*ant 10/04/26*
*4* *0*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*(A)* *Bf 10-4-26*

# Work Order ID 57965

April 21, 2010 9:17:23 AM



Page 3

Item ID: D4038-1

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, LH

Stop



Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

150



QC

Quality Control

QC3- Inspect Part Finish

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

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# Picklist Print

Page 1

April 21, 2010 9:17:22 AM

Work Order ID: 57965



Parent Item: D4038-1



Parent Item Name: Angle, Fwd, LH

Start Date: 21/04/2010

Required Date: 30/04/2010

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	14.5000	2.5263			

6061T6 ANGLE 4.00 x 4.00 x .250



## Warehouse

### Location

Main Warehouse

MAT06

## Loc Qty

113391

14.5

mm5-  
20/04/21

## Loc Code

2.9474

DART AEROSPACE LTD	Work Order:	57965
Description: Angle, Fwd, LH	Part Number:	4038-1
Inspection Dwg: 4038	Rev: R	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

X First Article      Prototype

Measured by:	<u>MW</u>	Audited by:	<u>mf</u>	Prototype Approval:	N/A
Date:	10/04/24	Date:	10/04/24	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

8

7

6

5

4

3

2

1

D

C

B

A

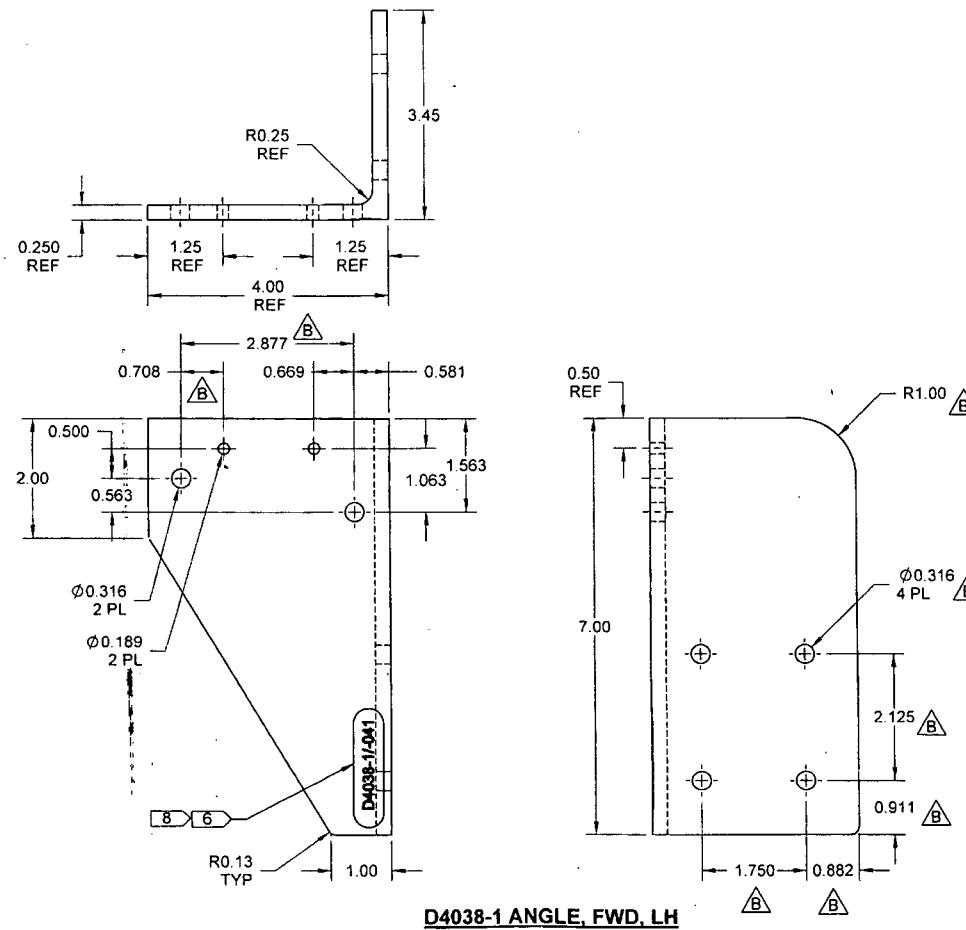
D

C

B

A

a/b 57965



RELEASED  
2010-04-14  
M

## NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.04 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN	<i>RE</i>	DART AEROSPACE LTD
DRAWN	<i>RE</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>RE</i>	DRAWING NO.
MFG. APPR.	<i>RE</i>	REV. B
APPROVED	<i>RE</i>	D4038
DE APPR.	<i>RE</i>	SHEET 3 OF 14
DATE 10.01.05		TITLE BRACKET
		SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS EXCLUDED FROM THE PUBLIC DOMAIN CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

## Work Order ID 57966

April 21, 2010 9:18:37 AM



Page 1

Item ID: D4038-2

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, RH

Stop



Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
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D4038	B
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100	
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Bandsaw	Memo
---------	------

Jeaspa Bandsaw	Cut Blank 7.125" long
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110	
-----	--

--	--

HAAS I	Memo
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HAAS CNC vertical machine #1	Mill as per Dwg & Folio FA880
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Dwg Rev: BFolio Rev: 244

Deburr

Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00							
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MW=  
10/04/21

4 05

MW=  
10/04/25

4 05

**Work Order ID 57966**

April 21, 2010 9:18:37 AM



Page 2

Item ID: D4038-2

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, RH

Stop



Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

MM= 10/04/25

4 Ø



QC

Quality Control

Memo

0.00

130

QC8- Inspect parts - second check

0.00

and 10/04/26

4 Ø



QC

Quality Control

Memo

0.00

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10

(4)

BF 10-4-26.

**Work Order ID 57966**

April 21, 2010 9:18:37 AM



Page 3

Item ID: D4038-2

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, RH

Stop



Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Memo

Set Up/  
Run Hours

0.00

Draw  
Number

10/04/26

Draw  
Rev.Plan  
CodeAccept  
Qty

X4

Reject  
Qty

Ø

Reject  
NumberInsp.  
Stamp

160



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

G.A Sylvie m-f w/04/26



Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/27 HJ  
MF 10-4-26

# Picklist Print

April 21, 2010 9:18:37 AM

Page 1

Work Order ID: 57966



Parent Item: D4038-2



Parent Item Name: Angle, Fwd. RH

Start Date: 21/04/2010

Required Date: 30/04/2010

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	14.5000	2.9474			

6061T6 ANGLE 4.00 x 4.00 x .250



## Warehouse

### Location

Main Warehouse

MAT06 14.5

113391 14.5

## Loc Qty

## Loc Code

*mva  
10/04/21*

2.9474

DART AEROSPACE LTD	Work Order:	57966
Description: Angle, Fwd, RH	Part Number:	D4038-2
Inspection Dwg: 4038 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>MJ</i>	Audited by:	<i>SMK</i>	Prototype Approval:	N/A
Date:	10/04/24	Date:	10/04/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

